

ABSTRACT OF THE DISCLOSURE

A method for the mechanical working of metals and alloys which comprises conducting the mechanical working in the presence of an aqueous cooling lubricant having a pH of 6-10 and containing a phosphate ester of the formula



where R_1 is an alkyl group with 1-12 carbon atoms, oxyalkylene is a group containing 2-4 carbon atoms, n is a number from 1-20, X is hydroxyl, $R_1\text{O}$ or $R_1(\text{oxyalkylene})_n\text{O}$, where R_1 , oxyalkylene and n have the meanings mentioned above, and m is a number from 4-40, or a salt thereof, and an alkenyl substituted succinic acid of the formula



where R_2 is an alkenyl group with 4-10 carbon atoms, or a salt thereof, or a mixture of any of the compounds I, II and III.